

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029388**Date Inspected:** 29-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

This report supersedes the TL-6031 report #WIR-029348 submitted March 29th 2013.

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Welder Chris Bruce #8901:

The welder was observed continue with welding the repair excavation on the Electroslag Weld "G" at face A, at Y location 1870 to 2330 as per Request for Weld Repair (RWR) 201303-005 in way of Ultrasonic Testing excavated indications. The indication was excavated to 400 long x 50 wide x 50 deep. The welder was observed preheating the weld to 216 degrees Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder utilized the Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Andrew Keech throughout the day and appeared to be in compliance with the WPS noted above.

Welder Terry McCormick #8494:

The welder was observed continue with welding the excavation on the Electroslag Weld "T" face A at Y location 3570 to 4000 as per Request for Weld Repair (RWR) 201303-007 in way of an Ultrasonic Testing excavated indications. The indication was excavated to 430 long x 75 wide x 58 deep. The welder was observed preheating the weld to 310 degrees Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder utilized the Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Arc Welding (SMAW). The welding parameters were verified by QC Inspector Andrew Keech throughout the day and appeared to be in compliance with the WPS noted above.

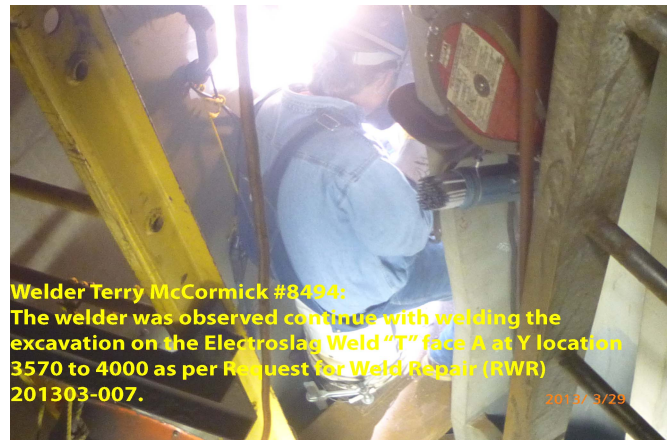
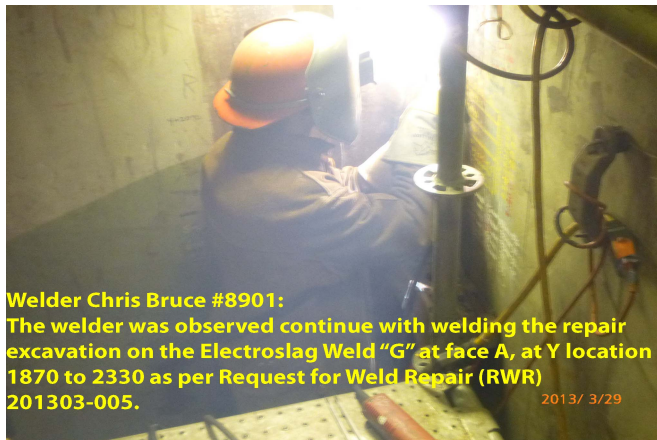
Non-Destructive Testing (NDT)

This QA performed VT, MPT & UTSW on the following:

- ESW "F" E-045, Y 500-1640 (RWR 201303-004).
- ESW "G" S-045, Y 7500-8500 (RWR 201303-002).
- ESW "V" S-045, Y 595-1610 (RWR 201303-006).

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
